Work Ordo		2838		*102	2838*						Page 1
Item ID: Revision ID:	D3234-1			Accept	*N900	<b>040</b>	100	)* s	•		S1*
Item Name: Start Date: Required Date:	Doubler 6/11/13 6/11/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:			50	** <b>*N</b>	S2*
Approvals:	Process Pl	an: WW.	Date(3612	Tooling: SPC (Y/N):		ate:		F		top	R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr									
D3234	С										
100 *100* Waterjet		FLOW WATER JET  Memo		0.00				6	0		JM13-12-9
FLOW CNC Water		1-Cut as per	_								
<b>ૢ</b> ૦૱५ : <b>૦</b> ૬૯*		Dwg Rev: Prog Rev: 2-Deburr if	<u>C</u>								,
110		QC2- Inspect parts off n	nachine FAI/FAIB	0.00							
*110*	<del>_</del> -	Memo		0.00				_6_			JMB-12-

Memo

Quality Control

DQA:			Date:										TRACCE
QA Closed:		ļ	Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / U		Vork Order u	ndate only	AEROSPACE
QA Closed.			Dutc.				_					····	
Work Orde	er:	į.				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
	•	į				Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	10.					Scrap		:	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
		1				Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	۱o.					Suspected Unapproved			Large Fab	Composite		Supplier	J
Root		÷			Desci	ription of work order update		nitial	Ac	tion	Sign &		1
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Design		i											
Doc/Data	Ш											ļ	
Equip/Tooling		:				•							
Handling/Pre													
Material		•											
Operator													
Offset/Setup											;		
Process													
Supplier	L						•					1	
Training													
Transport		1											
Unapproved									 				
l a a di						······ - , · · · · · · · · · · · · · · ·	FA	ULI CA	TEGORY			<del> </del>	
Landi		1 :				<b>General</b> Bend	_	]r=1:= /r		Г	70		7/5/
	-	Bending Centre No	at Cancar	ntria	-	BOM/Route	-	Grain	rogram	-	Outside Dim	<b>├</b>	Pressure/Forced
	$\vdash$	Cracks	or concer	itric	-	Broken/Damage/Defect	$\vdash$	1		-	Over/Under Part Incorre	ļ	Set-up
	<del>-</del>	Crimp/Kir	ak/Binnlo	Maya	-	Burrs	-	Hardwa	ire ion Incomplete/U	navalified	<del> </del>	<b>├</b>	Temperature/Cure
	-	Cuffs	ik) kibbie	y wave		Contamination	├	-1	•	· —	Part Lost/M		Weld
	$\vdash$	Crushing			$\vdash$	Countersink	$\vdash$	4	ions Incomplete/ gned/off center	Unclear	Part Moved Positioned \		Wrong Stock Pulled
	-	Heat Trea	nt .		-	Cut Too Short	-	Mislabe			Power Loss/	_	Other
	-	Inspection		Tube		Drawing	-	Misrea		L.	Trower ross/	Juige [_	Other
	_	Marks/Ch	· .			Drill Holes	$\vdash$	Off-set					
	$\vdash$	Turning S			$\vdash$	Finish	$\vdash$	-	Calibration				
		Wave/Tw				Fit/Function	$\vdash$	4	Sequence				
							1		<u> </u>				

Work Orde		2838		*1(	1283	38*						Page 2	
Item ID: Revision ID:	D3234-1			Accept	*1	1900	<b>040</b>	100	* s	etup Sta Sto		VS1*	
Item Name:	Doubler									50	ь <b>х</b> [	<b>US2</b> *	
Start Date: Required Date:	6/11/13 6/11/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*			Cust Item I Customer:	D:						
Reference: Approvals:	Process Pl	an:		Tooling:		Da	nte:		R	un Sta Sto	 	VR1*	
	QC:		Date:	SPC (Y/N):		Da	ıte:				, *I	<b>NR2</b> *	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hou		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Numb		
120		QC8- Inspect parts - seco	ond check		)AS 2 <b>7</b>				/				
*120* QC Quality Control		Memo			12/4				<u> </u>		<del></del>		
130		Chemical Conversion Co	oat per QSI005 4.1	0.00					j		4	- 2/	
*130* HandFinish Hand Finishing		Мето		0.00					6	_TH	3/23°	<u> 12-11</u>	
140		QC3 Inspect Part Finish	ı		DAS 27 9-89				/				

\*140\*

Quality Control

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DQA:		- !	Date:			WORK ORDER NON-	cc	NIEOI	DRARRICE / LI	IDDATE			DART
QA Closed:		!	Date:			WORK ORDER NON-		JINFOI	NIVIAINCE / O		Vork Order up	odate only	AEROSPACE
Mork Orde	· • ·	:				DISPOSITION			·,	AGAINST D	EPARTMENT	/PROCESS	
Work Orde	- 1					Rework			Skid-tube	Crosstube	٦	Water Jet	- Engineering
Part N	io	!				Scrap			Machining	Small Fab	- Dro	d. Eng. Coor.	Engineering Quality
raiti	٠٠	<u> </u>				Use-as-is			noforming	Finishing	_	re/Packaging	Other
NCR N	J۵	•				Suspected Unapproved		THETT	Large Fab	Composite	- Kec/3101	Supplier	
Henri	•••					Suspected Onapproved	J		raige (ab	composite		3dppner	
Root			,		Desci	ription of work order update	ı	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Design													
Doc/Data		•											
Equip/Tooling	Ш	:											
Handling/Pre		·	j										
Material							-						
Operator		'											
Offset/Setup		•					1	•					
Process													
Supplier													
Training		:		İ									
Transport							]						
Unapproved													
						· · · · · · · · · · · · · · · · · · ·	FAI	ULT CA	TEGORY	E.V. 10			·····
Landi	ng G	ear				General					_	_	<del></del>
	Ш	Bending				Bend		Folio/F	rogram	_	Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Ш	Cracks			L	Broken/Damage/Defect		Hardwa	ire		Part Incorre	ct _	Temperature/Cure
		Crimp/Kir	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	Inqualified	Part Lost/M	issing	Weld
		Cuffs				Contamination		Instruct	ions Incomplete/	'Unclear	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong	
		Heat Trea	t			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misread	t				
		Marks/Ch	atter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration				
	П	Wave/Tw	ist in Tub	ne .		Fit/Function		Out of	Sequence				

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Work Orde		02838	,	*102	2838*							Page 3
Item ID: Revision ID:	D3234-1 Doubler			Accept	*N900	<b>040</b>	100	)* :	Setup	Start Stop	1.7	S1* S2*
Item Name: Start Date: Required Date: Reference:	6/11/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item II Customer:	D:					IN.	<b></b> つ/
Approvals:	Process P	Plan:	Date:	Tooling:	Da	ıte:	_	J	Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	Da	nte:				Stop	*N	R2*
Sequence ID/ Work Center I  150  *150* Packaging Packaging	D	Operation Description Identify as per dwg & St	ock Location <b>8T</b>	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Re Qt		Reject Number	Insp. Stamp
160 *160* QC	· ·	QC21- Final Inspection	- Work Order Release	0.00				. (		/R	<u> 13-12</u>	24

Quality Control

u 13-12-11

DAS 26 9-89

DQA:		<u>:</u>	Date:			WORK ORDER NON-	cc	NEO	DNANICE / LID	DATE				``DART
QA Closed:		i	Date:			WORK ORDER NON-		JINFOI	NIVIAINCE / OF		Wo	rk Order up	date only	AEROSPACE
Work Orde	· ·					DISPOSITION				AGAINST I	DEP	ARTMENT	/PROCESS	
WOIR Olde	' -	·				Rework	i		Skid-tube	Crosstube	$\neg$		Water Jet	Engineering
Part N	io.					Scrap		1	Machining	Small Fab		Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing	_	Rec/Stor	e/Packaging	Other
NCR N	10	<u> </u>				Suspected Unapproved			Large Fab	Composite			Supplier	] []
Root					Desc	ription of work order update		nitial	Actio	on		Sign &		
Cause	$\perp$	Date.	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	$\downarrow$	Date	Verification	QC Inspector
Design	_													
Doc/Data	$\dashv$	,												
Equip/Tooling		,												
Handling/Pre	$\dashv$								·					
Material														
Operator Offset/Setup	-	:			1									
Process	$\dashv$	1		<u> </u>										
Supplier	-										1			
Training	$\dashv$	1												
Transport	$\dashv$													
Unapproved														
		÷		1	1		FA	ULT CA	TEGORY					
Landii	ng G	iear				General								
		Bending				Bend		Folio/F	Program			Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain				Over/Under	tolerance	Set-up
		Cracks <sub>.</sub>				Broken/Damage/Defect		Hardwa	are			Part Incorred	ct	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs	Г	Inspect	ion Incomplete/Und	qualified		Part Lost/Mi	ssing	Weld
		Cuffs				Contamination		Instruct	tions Incomplete/Ui	nclear		Part Moved		Wrong Stock Pulled
		Crushing				Countersink		]Misalig	gned/off center			Positioned V	Vrong	
		Heat Trea	it			Cut Too Short		Mislabe	eled			Power Loss/	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misread	d	_	_			
		Marks/Ch	atter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration					
		Wave/Tw	ist in Tub	ре		Fit/Function	$\perp$	Out of	Sequence					

Page 1

Work Order ID:

102838

Parent Item:

D3234-1

Parent Item Name:

Doubler

**Start Date: 6/11/13** 

Required Date: 6/11/13

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue 08-08-14 JLM Verified By:EC

IPP Rev:B 08-12-18 as per ECN08-582 DD verified by:EC ECN11-674 DD VERF:EC

IPP REV:C 11.11.24 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080 2024-T3 .080 sheet		Purchased	No			100	sf	88.7500	0.58	3.6631578		Jn	n13-12-
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT022		88.75							
				12321	17	27.75							
				12563	36	61							
					. 12				127	668			

127668

DQA:		· · · · · · · · · · · · · · · · · · ·	Date:			WORK ORDER NON	cc		20400165 / 111				TAAG
QA Closed:			Date:			WORK ORDER NON-	-CC	JNFUI	RIVIAINCE / UI		Vork Order u	odate only	AEROSPACE
<b>14 1</b> - <b>0 1</b>			·			DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Work Orde	er: _	<del></del>				·	. 1		a		7		
Down N						Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	NO	1				Scrap Use-as-is			Machining	Small Fab	_	d. Eng. Coor.	Quality Other
NCR N	do					Suspected Unapproved		mem	noforming Large Fab	Finishing Composite		re/Packaging Supplier	- Other
WCI !	•0. –					Juspected Ollappioved	İ		Large Fab	Composite		20hbuei [	
Root					Desci	ription of work order update	!	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Design						•							
Doc/Data			1										
Equip/Tooling		:											
Handling/Pre	Ш				İ								
Material	Ш												
Operator	Ш										•		
Offset/Setup													
Process													
Supplier													
Training													
Transport			]										
Unapproved											1		
							FAL	JLT CAT	EGORY				
Landi	ng G	ear				General							
		Bending				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced
	∐'	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
1		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorre	ct	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Ur	nqualified	Part Lost/Mi	ssing	Weld
		Cuffs				Contamination		Instruct	ions Incomplete/U	Jnclear	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center	Γ	Positioned V	Vrong	
		Heat Trea	it			Cut Too Short		Mislabe	led	Γ	Power Loss/	Surge	Other
		nspection	n Strip in	Tube		Drawing		Misread	1		_		
•		Marks/Ch	atter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of (	Calibration				
	Inspection Strip in Tu Marks/Chatter Turning Sequence Wave/Twist in Tube		oe		Fit/Function		Out of 9	Sequence					

3 D С D3234-3 DOUBLER D3234-5 SPACER D3234-1 DOUBLER В NOTES: 1) MATERIAL: -1: 2024-T3 ALUMINUM SHEET, 0.080 THICK PER AMS-QQ-A-250/4 OR AMS 4037 REF DART SPEC M2024T3S.080 RE-DESIGNED D3234-1 TO FIT D3025-1 REV. B. ZONE C3-2, 4.505 WAS 5.347, ZONE D8-2, 2.700 WAS 2.841. REASON: REF PAR 11-118. -3: 2024-T3 ALUMINUM SHEET, 0.050 THICK PER AMS-QQ-A-250/4 OR AMS 4037 REF DART SPEC M2024T3S.050 DC 11.09.29 REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. PARTS FULLY DIMENSIONSED. NO PHYSICAL CHANGES MADE TO PARTS. REASON: REF PAR 08-029. AJS 08.11.24 -5: 5052-H32 ALUMINUM SHEET, 0.050 THICK PER AMS-QQ-A-250/8 OR AMS 4016 REF DART SPEC M5052H32S.050 Α NEW ISSUE CP 03.11.19 REV. DESCRIPTION BY DATE DESIGN 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
7) WEIGHT: -1: 0.41 lbs
-3: 0.15 lbs
-5: 0.01 lbs DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. C D3234 MFG. APPR.

4

SHEET 1 OF 2

SCALE

NTS

APPROVED

11.09.29

DE APPR.

DATE

3

TITLE

2

**DOUBLER** 

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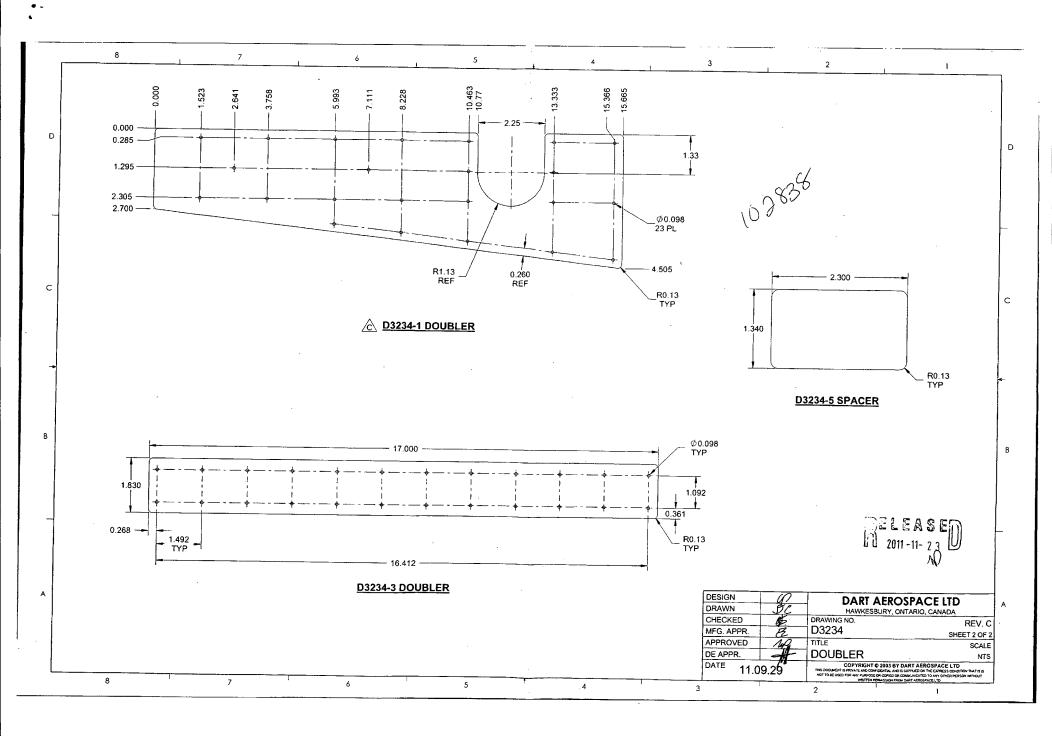
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DQA:	·· .		Date:												A DT
0.4.61			5.			WORK ORDER NON	-CC	ONFO	RMANCE / U	PDATE			·		AEROSPACE
QA Closed:			Date:								W	ork Order up	odate only		
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
Part N	- No					Rework Scrap Use-as-is Suspected Unapproved		1	Skid-tube  Machining noforming  Large Fab	Crosstube Small Fab Finishing Composite		4	Water Jet d. Eng. Coor. re/Packaging Supplier	En	gineering Quality Other
Root					Descr	ription of work order update		nitial	۸۵	tion		Sign &		ſ	
Cause		Date	Step	Qty	<i>D</i> C 3 C 1	or non-conformance	1	ief Eng		ription		Date	Verification		QC Inspector
Design		Date	эсер	Qty		or non comormance	CII	nei Ling	Desc	прион		Date	vermeation	<del>'</del>	ac mspector
Doc/Data															
Equip/Tooling															
Handling/Pre															
Material	$\Box$														
Operator															
Offset/Setup															
Process	П														
Supplier															
Training												·			
Transport	П														
Unapproved	П														
==							FAI	ULT CAT	EGORY						
Landi	ng Ge	ear				General									
		Bending				Bend		Folio/P	rogram		Γ	Outside Dim	ensions	Pres	sure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Г	Over/Under	tolerance	Set-	up
		Cracks				Broken/Damage/Defect		Hardwa	re		Г	Part Incorred	ct	Tem	perature/Cure
		Crimp/Kin	ık/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/U	nqualified		Part Lost/Mi	ssing	Weld	d
		Cuffs				Contamination	Г	Instruct	ions Incomplete/	Unclear	Г	Part Moved	Γ	Wro	ng Stock Pulled
		Crushing				Countersink		Misalig	ned/off center			Positioned V	Vrong		
i	ı	Heat Trea	t			Cut Too Short		Mislabe	eled			Power Loss/	Surge	Othe	er
		nspection	n Strip in	Tube		Drawing		Misread	t						
		Marks/Ch	atter			Drill Holes		Off-set							
		Furning So	equence			Finish		Out of 0	Calibration						
		Wave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence	•					

<sup>:</sup> H:/FORMS/Quality Assurance\approved QA/NCRWO RevH



DQA:			Date:			_								A DT
QA Closed:			Date:			WORK ORDER NON	1-C	ONFO	RMANCE / U		Vork Order up	odate only	: 	AEROSPACE
Work Ord	er:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS		
Part I						Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Desc	ription of work order update		Initial	A	ction	Sign &			······································
Cause		Date	Step	Qty		or non-conformance	Cr	nief Eng	Des	cription	Date	Verification	n	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														
							FA	ULT CA	TEGORY				:	
Landi	ing (	Gear Bending Centre No Cracks Crimp/Kii				General Bend BOM/Route Broken/Damage/Defect Burrs		Grain Hardwa	Program are ion Incomplete/V	Unqualified	Outside Dim Over/Under Part Incorre	tolerance ct	Se	ressure/Forced et-up emperature/Cure reld
		Cuffs Crushing Heat Trea Inspectio Marks/Ch	at n Strip in natter	Tube		Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Instruct Misalig Mislabe Misread Off-set	tions Incomplete gned/off center eled d	/Unclear	Part Moved Positioned V Power Loss/	Vrong	w	rong Stock Pulled
	Turning Sequence Wave/Twist in Tube		e		Fit/Function		Out of	Sequence				:		

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DART AEROSPACE LTD	Work Order:	10.2838
Description: Doubler	Part Number:	D3234-1
Inspection Dwg: D3234 Rev: C	1	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.099	_		. V.,	Jamoi
0.285	+/-0.010	0.285	_		V	
1.295	+/-0.010	1.297	_		V	·
2.305	+/-0.010	2307"	-		V	
2.700	+/-0.010	2.704	_		V	
4.505	+/-0.010	4.505	_		V	
1.33	+/-0.030	1.33"	_		V	
1.523	+/-0.010	1.525	-		v	
2.641	+/-0.010	2641"	-		<b>V</b>	
3.758	+/-0.010	3.755"	-		V	
5.993	+/-0.010	5.993"	-		V	
7.111	+/-0.010	7.111			~	
8.228	+/-0.010	8.728"	-		V	
10.463	+/-0.010	10.465	-		7	Throu
10.77	+/-0.030	10.77"	•		T	Janos
2.25	+/-0.030	215	_		γ	
13.333	+/-0.010	13.331	_		Т	
15.366	+/-0.010	15.366	_		Ť	
15.665	+/-0.010	15.665	_		T	
0.080	+/-0.010	0.080"	-		v	
			DAS			

Measured by: Jm	Audited by:	9-89	Preliminary Approval:						
Date: 13-12-9	Date:	13/12/09	Date:						

Rev	Date	Change	Revised by	Approved
Α	08.09.04	New Issue	KJ/DD	1.5.00
B	09.05.04	Dimensions update per Rev B	KJ/DD (A	1. A
С		Dimensions update per Rev C	KJ del	<del>                                      </del>
		- who have apacto per recy o	173 781	L / <b>X</b> /

DQA:		_ Date:											
QA Closed:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE  Work Order update only  Work Order update only								
Work Orde	er:				DISPOSITION		AGAINST DE			EPARTMENT/PROCESS			
Part No.			Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Crosstub Machining Small Fa noforming Finishin Large Fab Composit	b g	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other			
New No.			Suspected Oliappioved Large Pab Colliposite										
Root				Desc	ription of work order update		Initial	Action		Sign &	·		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector	
Design													
Doc/Data								,					
Equip/Tooling													
Handling/Pre												]	
Material													
Operator													
Offset/Setup												t.	
Process													
Supplier												'	
Training	i												
Transport													
Unapproved										1.7			
FAULT CATEGORY													
Landir	ng Gear				General		_						
	Bending				Bend		Folio/F	Program	Г	Outside Dim	ensions	Pressure/Forced	
	Centre Not Concentric				BOM/Route		Grain		Г	Over/Under	tolerance	Set-up	
	Cracks				Broken/Damage/Defect		Hardware		Г	Part Incorrect		Temperature/Cure -	
	Crimp/Kink/Ripple/Wave				Burrs		Inspection Incomplete/Unqualified		Г	Part Lost/Missing		Weld	
	Cuffs				Contamination		Instructions Incomplete/Unclear			Part Moved		Wrong Stock Pulled	
	Crushing				Countersink		Misaligned/off center			Positioned Wrong			
	Heat Treat				Cut Too Short		Mislabeled			Power Loss/Surge		Other	
	Inspection Strip in Tube				Drawing		Misread			_		•	
	Marks/0	hatter			Drill Holes		Off-set						
	Turning Sequence				Finish		Out of	Calibration					
	Wave/Twist in Tube				Fit/Function		Out of	Sequence					